

Work Order ID 72379



Page 1

Monday, July 25, 2011 9:14:38 AM

Item ID:	D3325-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	7/25/2011	Start Qty:	1.00			
Required Date:	8/2/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	12-06-06	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3325	Rev B

100		0.00
	Large Fab	
Large Fab		0.00
Large Fab		

(1x)

12-06-05

Memo

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	1112786
3	D3325-3	Interior Tube	1112786
2	D3325-5	Full Length Tube	1112786

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
A/R 4130 Steel Rod 119317

4-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Q41 lid scrap due to specin Bluen						

NOTE: Date & initial all entries

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Item ID: D3325-041

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Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE266/05

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scrubbers

121

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

M-L
12/6/05
IX 0

W/O:		WORK ORDER CHANGES					
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Setup Start



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Stop



Item Name: Basket Lid Assembly

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

1ST COAT:

START TIME: 2:45

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:45

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 3:30

OVEN TEMPERATURE: 400°F

FINISH TIME: 4:00

IX

Ø

M-L
12/06/05

IX

Ø

M-L
12/06/05

1

Ø

B/12-0-6

140

QC3- Inspect Part.Finish

0.00



QC

Quality Control

Memo

0.00

M121134

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>D350-72</u> Memo	0.00 0.00	<u>84903</u>			<u>1</u>	<u>φ</u>	<u>BL 126-6</u>	
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>MLJ 12/06/06</u> <u>ME</u> <u>12-06-06</u>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 12, 2011 12:41:56 P

Page 1

Work Order ID: 72379

Parent Item: D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

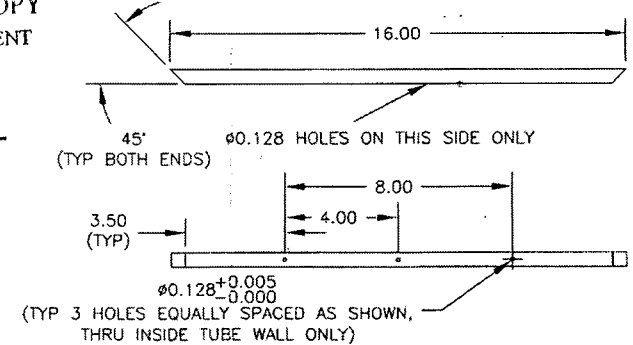
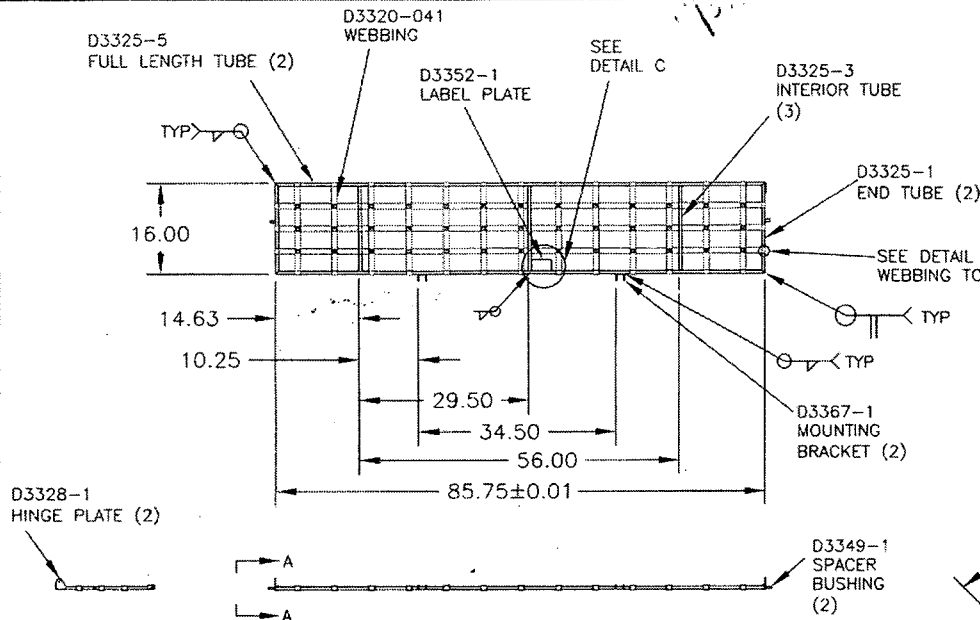
Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3328-1 Basket Hinge		Manufactured	No			100	Each	25.0000	2	2		11/10/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		25							
				33871		25							
✓ D3349-1 Spacer Bushing		Manufactured	No			100	Each	30.0000	2	2		11/10/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		30							
				34205		2							
				44401		28							
✓ D3352-1 Label Plate		Manufactured	No			100	Each	15.0000	1	1		11/10/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		15							
				41925		15							
✓ D3367-1 Mounting Bracket		Manufactured	No			100	Each	24.0000	2	2		11/10/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		24							
				43228		24							
✓ M4130NTS0.500W.035 4130 Square tube .500 x .500 x .035w		Purchased	No			100	f	343.6688	20.5416	21.622737		11/10/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT034		343.6688							
				109127		216							
				109385		15.75							
				112786		111.9188							

21.62 + 1 END BAR SCRAP

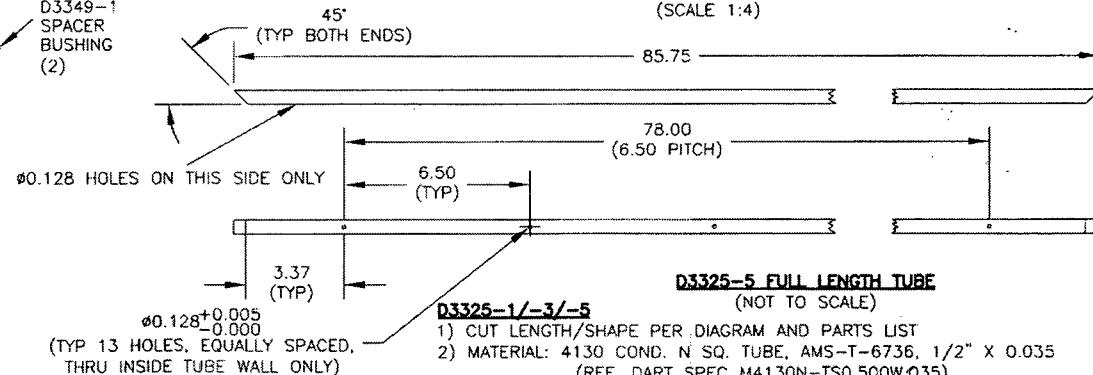
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **72329**
11/07/29



D3325-1 END TUBE
(SCALE 1:4)

D3325-3 INTERIOR TUBE
(SCALE 1:4)



D3325-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20690AD4W3	32	RIVET
AN960JD9	32	WASHER

RELEASED
05-04-29

DEO ATTACHED

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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART DART AEROSPACE LTD. THAMESBURY, OXFORD, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325
DATE 05.04.25	TITLE BASKET LID ASSEMBLY	REV. B SHEET 1 OF 3 SCALE 1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

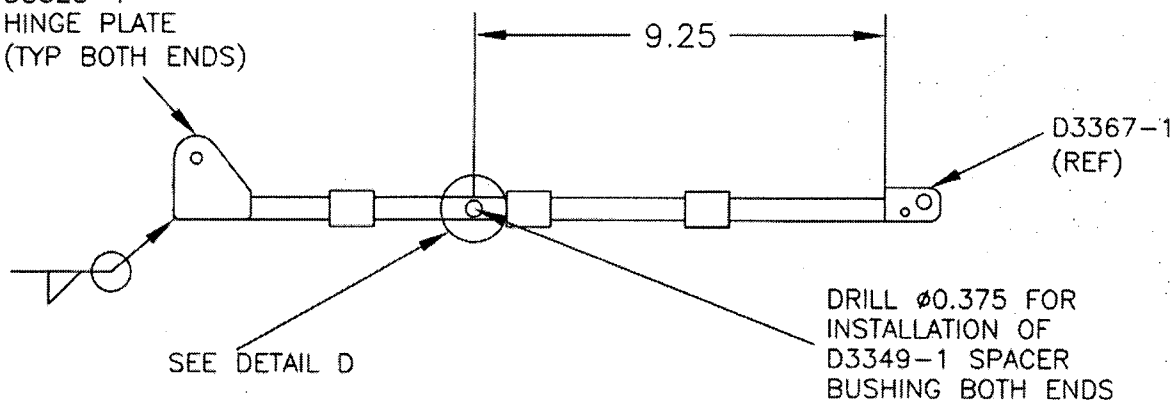
NOTE: Date & initial all entries



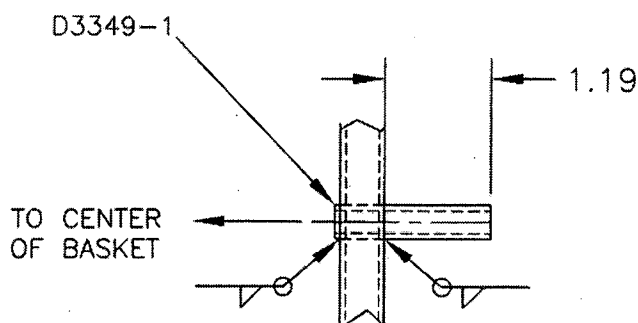
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

72379

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A



DETAIL D
(SCALE 1:2)

DEO ATTACHED
RELEASED
05-04-28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

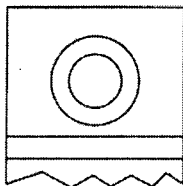
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

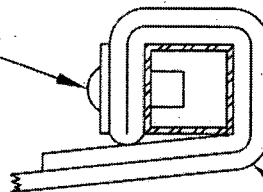


72370

DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. 8 SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

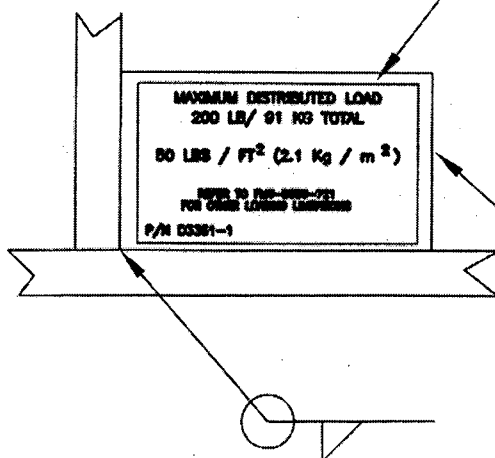


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28
DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01		DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

12379

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET
--------------	----	-------

WAS:

MS20600AD4W3	32	RIVET
--------------	----	-------

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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